

Work Order ID-72378

Monday, July 25, 2011 9:14:16 AM



Page 1

Item ID: D3324-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly

Start Date: 7/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date:

10/25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3324

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut tubes as per Dwg D3324

Qty Part Number Description Batch

3 D3324-1 Bottom Tube *1112786*

4 D3324-3 Full Length Tube *1112786*

2 D3324-5 Top End Tube *1112786*

2 D3324-7 Bottom End Tube *1112786*

10 D3324-9 Vertical Tube *1112786*

2- Weld as per dwg

A/R 4130 rod batch: *119317*

11/10/13 *(1x)*

Pro ->

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1 0 12/05/08

W/O: 72378		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3324-041 PAR #: _____ Fault Category: Large Faw / Basket welding NCR: (Yes) No DQA: AK Date: 12/05/14
 Resolution: use as in Disposition: use as is QA: N/C Closed: AK Date: 12/5/14

NCR: 12-1471		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/10/14	# 120	welded welds @ L.P. #3. in the wing location. welds it @ 26.5" should be 29.5". R.L. LOA. welds bent from the wing end to measure from	<u>AK</u> 12/05/14	→ acceptable deviation this time only. Retrain Employee/welder to pay closer attention	<u>AK</u> 11/10/14	<u>S</u> 12/05/14	<u>AK</u> 12/05/14	<u>S</u> 11/10/14
		(Drawing - No are correct).	<u>AK</u> 12/05/14	A custom made lid will be req'd. w/ ribs to match this base Assy. AND LOCATION OF LABEL	<u>AK</u> 12/05/14		<u>AK</u> 12/05/14	<u>S</u> 11/10/14
			<u>AK</u> 12/05/14	PLATE ON LID MIGHT NEED TO BE LOCATED DIFFERENTLY AS WELL. ALL CHANGES TO BE WRITTEN UP ON D3325-041 BN 740FF	<u>AK</u> 12-05-08 Y	<u>S</u> 12/05/14	<u>AK</u> 12/05/14	<u>S</u> 11/10/14

NOTE: Date & initial all entries

Work Order ID 72378

Monday, July 25, 2011 9:14:16 AM



Page 2

Item ID: D3324-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly

Start Date: 7/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

8/7/10/8

Memo

121



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

0.00

N/A

Memo

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72378

Monday, July 25, 2011 9:14:16 AM



Item ID:	D3324-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Base Assembly					
Start Date:	7/25/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	8/2/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				1X	0		M.F. 12/5/09
<div style="display: flex; justify-content: space-between;"> <div>M121134</div> <div> <p>Memo</p> <p>1ST COAT: 8-15 400°F</p> <p>START TIME: 8-45</p> <p>OVEN TEMPERATURE: 8-45</p> <p>FINISH TIME: 8-45</p> <p>***** 2nd coat if necessary *****</p> <p>2ND COAT: 9-10 400°F</p> <p>START TIME: 9-40</p> <p>OVEN TEMPERATURE: 9-40</p> </div> </div>									
140 QC	QC3- Inspect Part Finish	0.00				1	0		BLD 5-9
Quality Control	Memo	0.00							

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72378

Monday, July 25, 2011 9:14:16 AM



Page 4

Item ID: D3324-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly

Start Date: 7/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: D350-72378-041



Packaging

Memo

0.00

Packaging

1 ϕ BL 125-9

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12/5/10 ϕ
MW 12/05/09

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, July 25, 2011 9:14:22 AM

Page 1

Work Order ID: 72378

Parent Item: D3324-041

Parent Item Name: Basket Base Assembly





Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 05.02.09 New issue KJ/JLM
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 Basket Hinge		Manufactured	No			100	Each	26.0000	2	2		11/10/12	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				26					
					33872			26					
 Clevis		Manufactured	No			100	Each	9.0000	4	4		11/10/12	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				9					
					44246			9					
 Spacer Bushing		Manufactured	No			100	Each	2.0000	2	2		11/10/11	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				2					
					41831			2					
 Mounting Bracket		Manufactured	No			100	Each	24.0000	2	2		11/10/12	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				24					
					43228			24					

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Monday, July 25, 2011 9:14:22 AM

Work Order ID: 72378

Parent Item: D3324-041

Parent Item Name: Basket Base Assembly

Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035 Purchased No

100

f

343.6688

46.6

49.05263



4130 Square tube .500 x .500 x .035w



11/10/12

Location

Loc Qty

Loc Code

MAT034

343.6688

109127

216

109385

15.75

112786

111.9188

M569EX0.50-18F Purchased No

100

sf

46.0000

28

28



569 Expanded Metal



11/10/12

Location

Loc Qty

Loc Code

MAT018

46

112776

10

117806

36

32

Monday, July 25, 2011 9:14:23 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



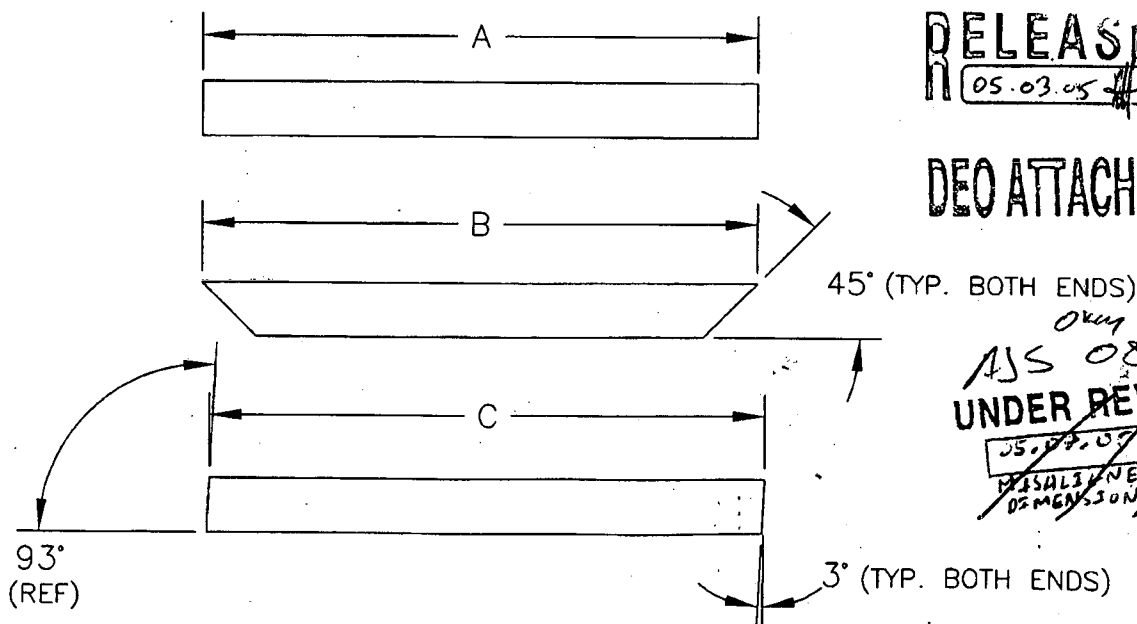
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 72378

DESIGN RH	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.20	NEW ISSUE	
B	05.03.04	UPDATE MESH MATERIAL SPEC	

RH 11.07.25 PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



RELEASED
05.03.05 **#**

DEO ATTACHED

45° (TYP. BOTH ENDS)

OK
155 08.12.15
UNDER REVIEW
05.07.07 **RH**
MISALIGNED
DIMENSION PG 2

93°
(REF)

3° (TYP. BOTH ENDS)

D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL
(REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2005 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

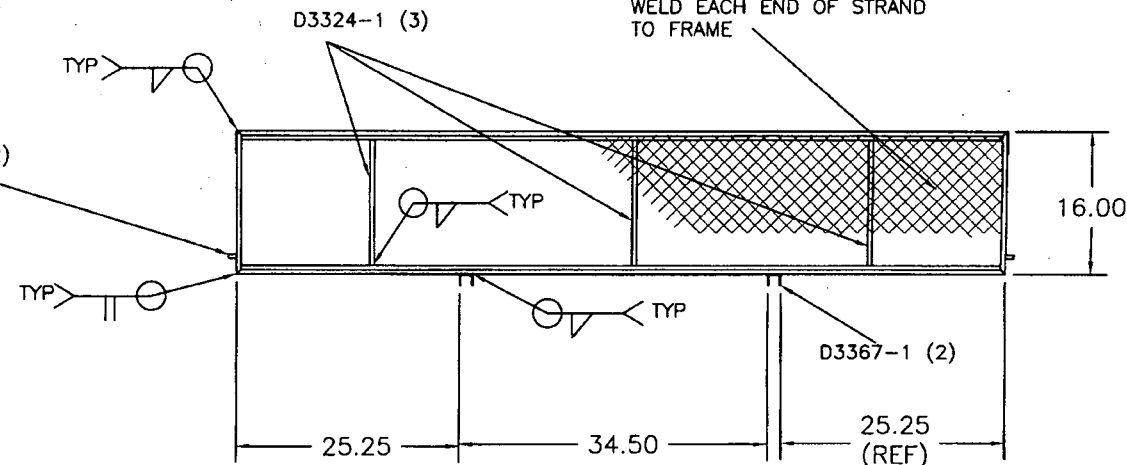
NOTE: Date & initial all entries

DART

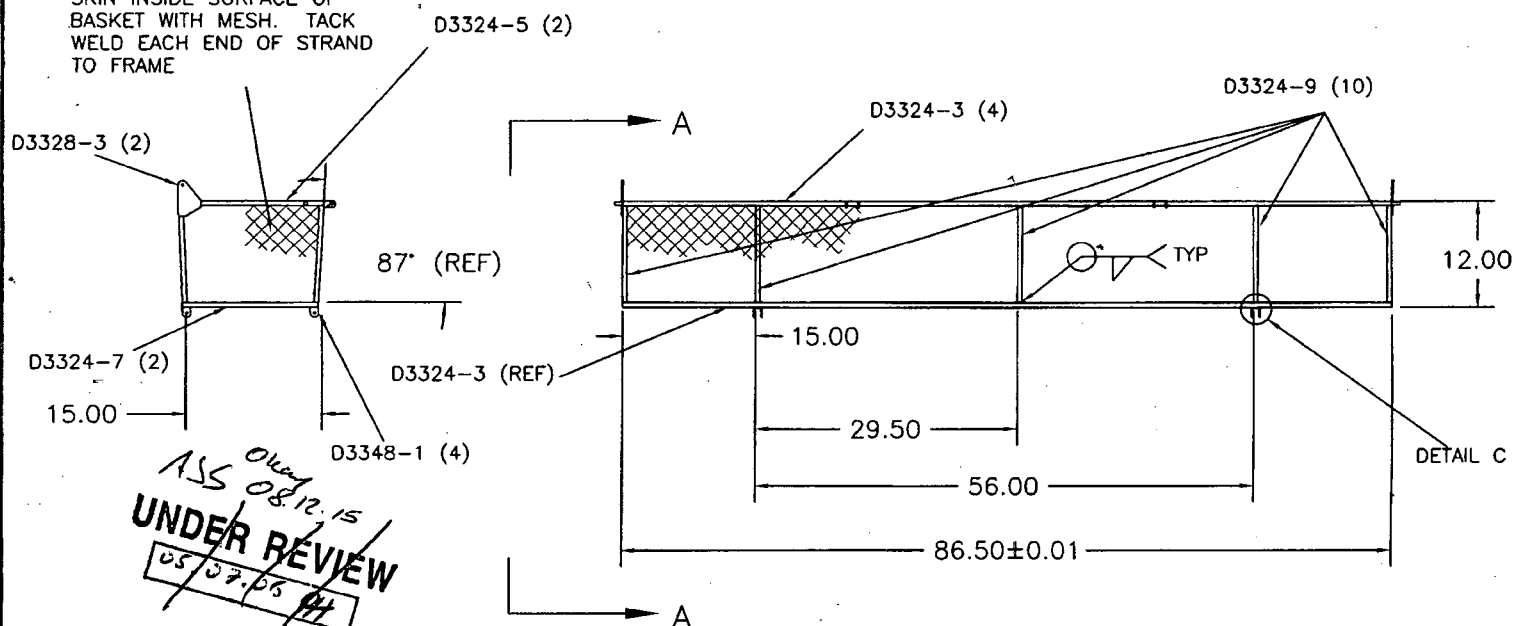
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	DRAWING NO. D3324
DATE	05.03.04	TITLE	BASKET BASE ASSEMBLY	REV. B SHEET 2 OF 3
		SCALE	1:20	

19378

SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME



SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME



D3324-041 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

RELEASED
05.03.05

UNO ATTACHED

ASS Okay 08.12.15
UNDER REVIEW
05/07/06

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

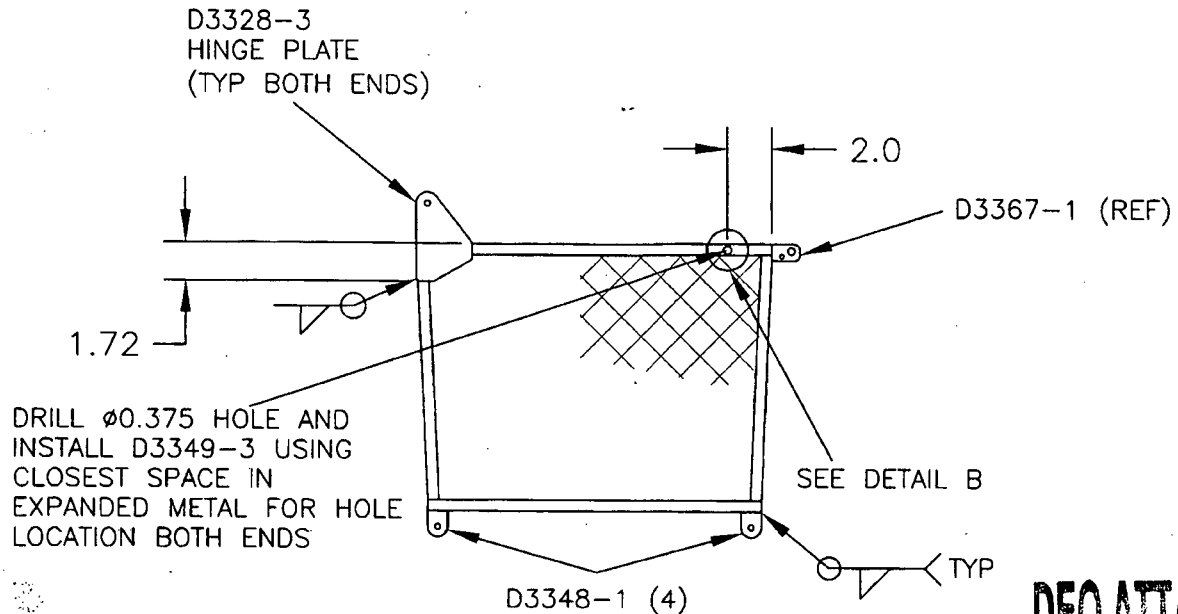
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

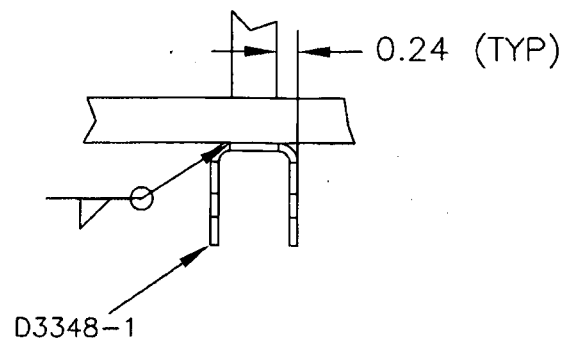
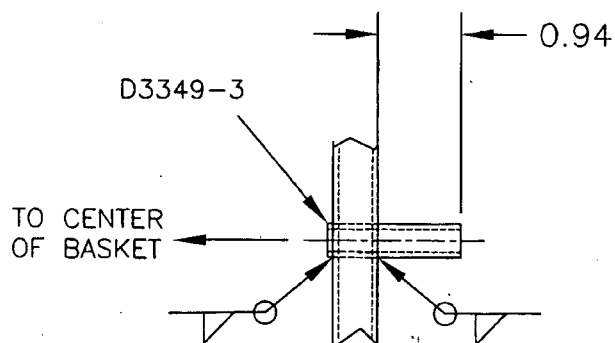
72878

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3324	REV. B SHEET 3 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8



DEO ATTACHED

RELEASED
05.03.05



OK
ASS 08.12.15
UNDER REVIEW
05.07.05

Copyright © 2005 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

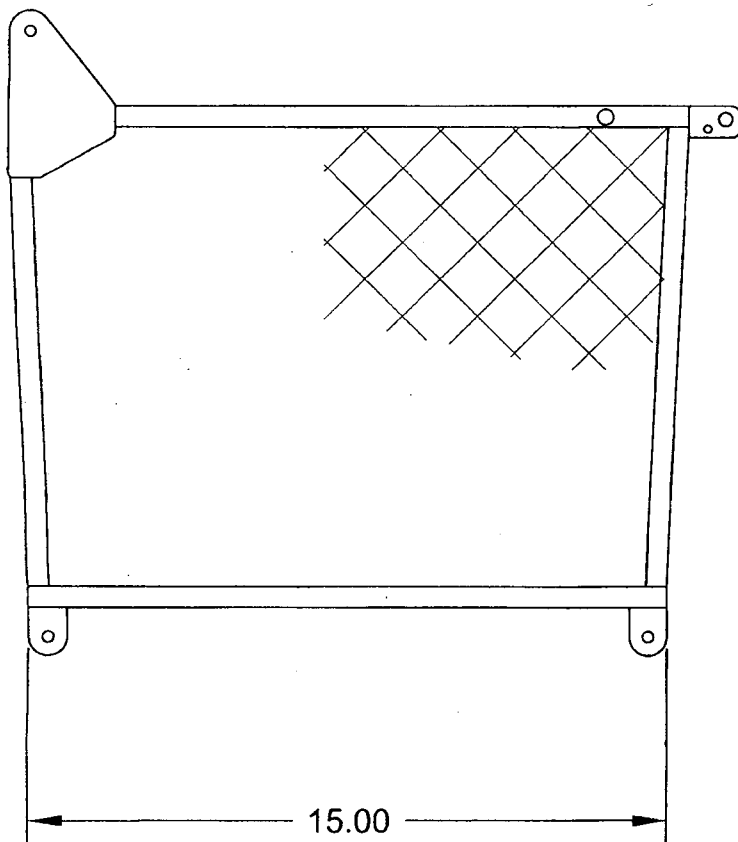
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

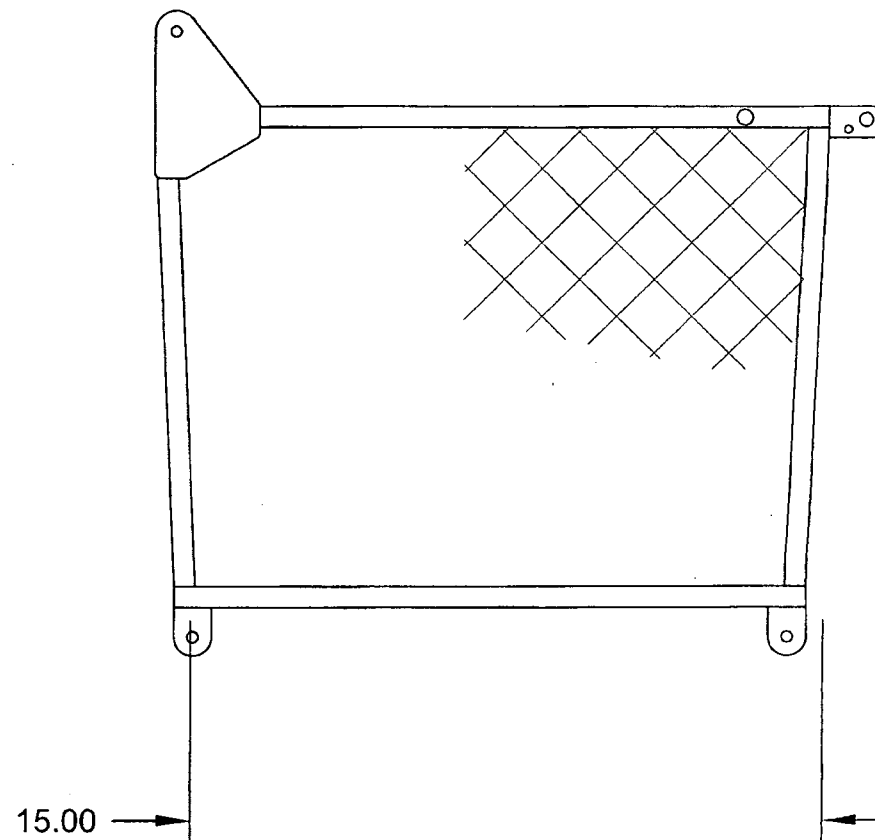
DRAWING NO. D3324	TITLE BASKET BASE ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3324-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 08.11.28	DATE 08.11.28	DATE 08/12/01	DATE 08/12/01		DATE 08.12.01		

SHEET 2 MODIFY SIDE VIEW OF D3324-041 AS SHOWN:

IS:



WAS:



72378

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries